

Date: Wednesday, 1/31/2007 2:19:44 PM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|---------------------------------------|--|------------------|------------------|-----|------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : SUPPORT | | |
| Job Number | : 30563B | | Part Number | : D32782 | | |
| Estimate Number | : 10462 | | Drawing Number | : D3278 REV. B | | |
| P.O. Number | : N/A | | Project Number | : N/A | | |
| This Issue | : 1/31/2007 | | Type | : SMALL /MED FAB | | |
| Prsht Rev. | : NC | | Drawing Revision | : B | | |
| First Issue | : N/A | | Material | : N/A | | |
| Previous Run | : 30276B | | Due Date | : 2/28/2007 | | |
| Written By | | | Qty: | 20 | Um: | Each |
| Checked & Approved By | | | | | | |
| Comment | : Est:A 0404.19 | | New issue KJ/JLM | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|--|
| 1.0 | M6061T6B1000X02000 | 6061-T6 Bar 1.0" x 2.0" |
| Comment: Qty.: 0 f(s)/Unit Total: 5 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Batch: <u>M19295</u> <u>ML 07/02/17 27</u> | | |
| 2.0 | SHEAR | SHEAR |
| Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long <u>ML 07/02/17 27</u> | | |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-2 <u>ML 07/02/17 27</u> | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ML 07/02/17 27</u> | | |
| 5.0 | QC8 | SECOND CHECK |
| Comment: SECOND CHECK <u>J.F. 07/02/24 27</u> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/28
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:19:44 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 30563B

Part Number: D32782

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



27X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m/f/yl

07/02/06

7.0 POWDER COATING

POWDER COATING



m103141



27

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

fx/m/f 07/02/26

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

6/7/28 (27)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

o C 7/2/28

27

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

o 07/02/28

Job Completion



U 07/02/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 30563B |
| Description: Support | Part Number: | D3278-2 |
| Inspection Dwg: D3278 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | Ø0.098 | — | | | |
| 0.359 | +/-0.005 | 0.359 | — | | | |
| 0.609.0615 | +/-0.010 | 0.610 | — | | | |
| 0.250 | +/-0.010 | 0.250 | — | | | |
| 1.480 | +/-0.005 | 1.479 | — | | | |
| R0.125 | +/-0.010 | R0.125 | — | | | |
| 0.119 | +0.005/-0.004 | 0.120 | — | | | |
| 2.439 | +/-0.010 | 2.431 | — | | | |
| | | | | | | |
| 1.980 | +/-0.010 | 1.981 | — | | | |
| R0.130 | +/-0.010 | R0.130 | — | | | |
| Ø0.257 | +0.005/-0.000 | Ø0.258 | — | | | |
| R0.375 | +/-0.010 | R0.375 | — | | | |
| 0.875 | +/-0.010 | 0.874 | — | | | |
| 0.500 | +/-0.010 | 0.499 | — | | | |
| R0.400 | +/-0.010 | R0.400 | — | | | |
| | | | | | | |
| 1.720 | +/-0.010 | 1.721 | — | | | |
| R0.125 | +/-0.010 | R0.125 | — | | | |
| 0.125 | +/-0.010 | 0.126 | — | | | |
| | | | | | | |
| | | | | | | |

| | | | | | |
|--------------|-------------|-------------|-------------|---------------------|-----|
| Measured by: | <i>John</i> | Audited by: | <i>J.F.</i> | Prototype Approval: | N/A |
| Date: | 07/02/19 | Date: | 07/02/19 | Date: | N/A |

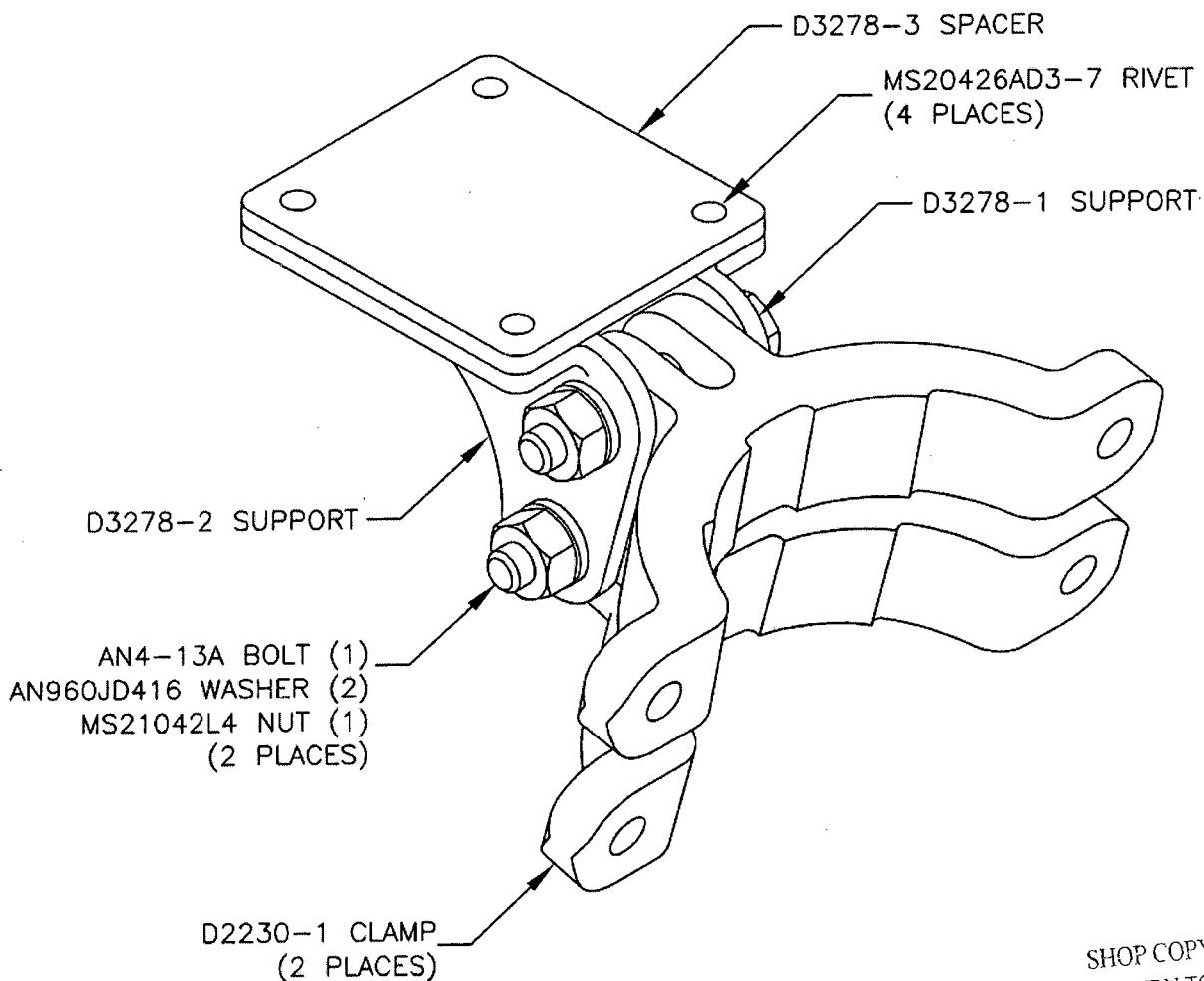
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|-------------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | <i>J.F.</i> |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM | <i>J.F.</i> |



| | | |
|-------------------------------|--------------------------------|---|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3278 |
| DATE 05.03.31 | | TITLE SUPPORT ASSEMBLY |
| | | SCALE NTS |
| A | 04.03.03 | NEW ISSUE |
| B | 05.03.31 | CHANGE DIM/TOL TO ENSURE FIT |

RELEASED
05.04.04 *[Signature]*

D3278-041 SUPPORT ASSEMBLY



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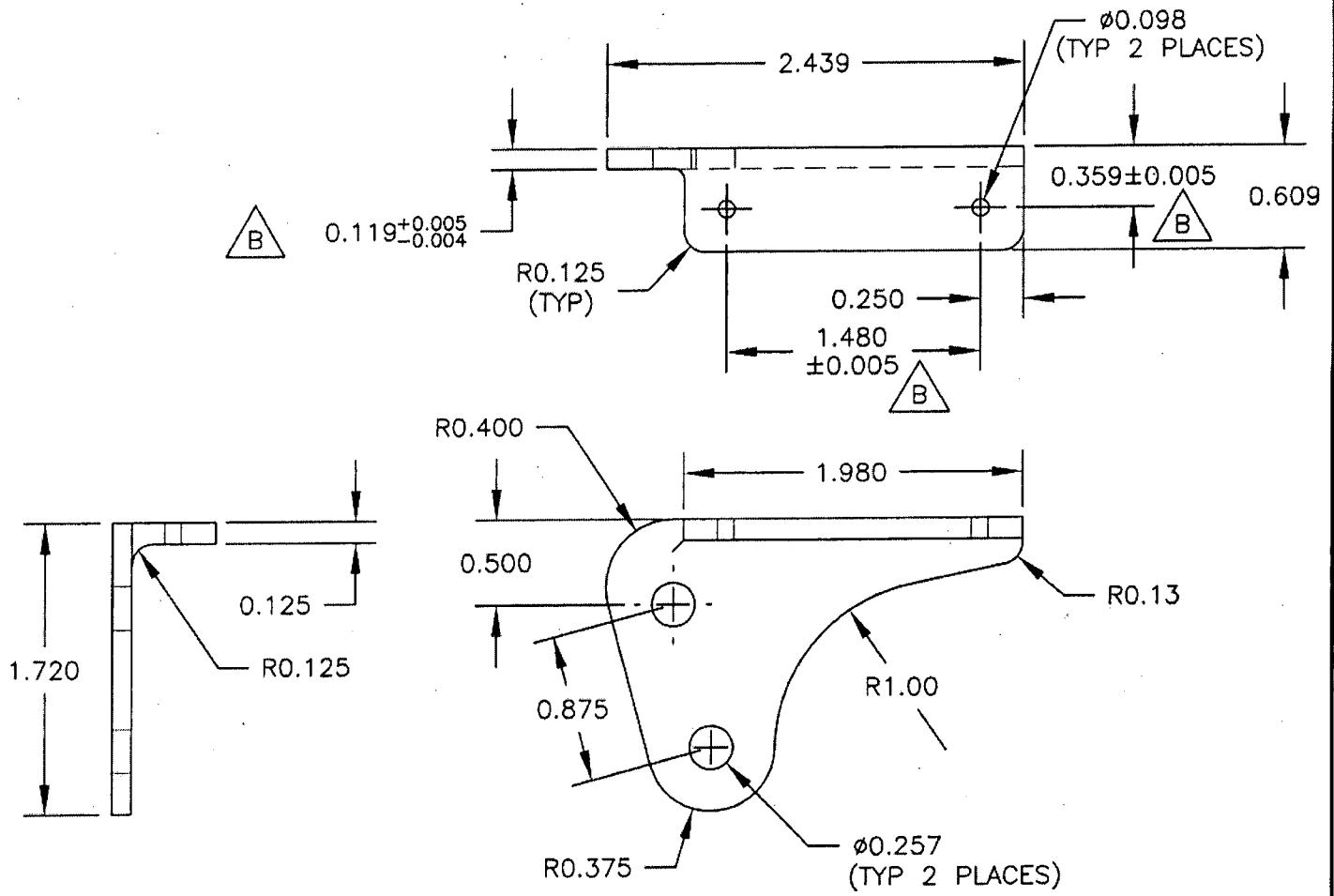
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| DATE 05.03.31 | TITLE SUPPORT ASSEMBLY | REV. B SHEET 2 OF 3 SCALE 1:1 |

RELEASED

05.04.04 *[Signature]*



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11) TO ENGINEERING
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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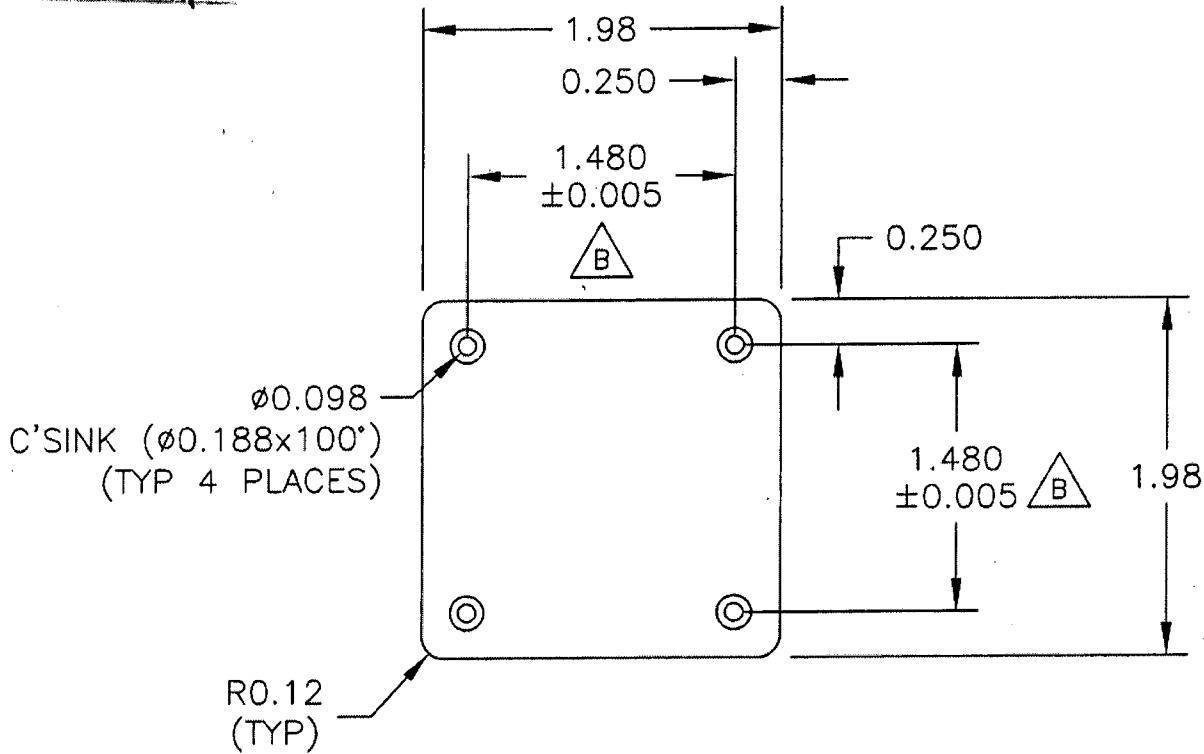
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| CHECKED <i>[initials]</i> | APPROVED <i>[initials]</i> | DRAWING NO. D3278 |
| DATE 05.03.31 | TITLE SUPPORT ASSEMBLY | REV. B SHEET 3 OF 3 SCALE 1:1 |

RELEASED

05.04.04 *[initials]*



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR 0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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